

Date: Monday, 18/08/2008 3:31:46 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM
Job Number	: 41316A03			
Estimate Number	: 10145			
P.O. Number	:		Part Number	: D2037101
This Issue	: 18/08/2008 S.O. No. :		Drawing Number	: D2037 REV D
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB		Drawing Revision	: D
Previous Run	: 40007		Material	:
Written By	:		Due Date	: 10/09/2008 Qty: 4 Um: Each
Checked & Approved By	<u>STUO 08.8.18</u>			
Comment	: Est Rev:A New Issue 05-11-01 JLM Est Rev:B 08-07-29 revD as per dwg DD verified by:EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: <u>M110113</u>	<u>Sb 09/01/08</u> (4)
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1	<u>Sb 09/01/08</u> (4)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037	(4)
		2-Flatten ends of D2037-101 tube as required using DT8545	88
		3-Deburr as required	<u>m-h 09/01/12</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>S 09/01/12</u> (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>P 9/01/12 (4)</i>
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>09/01/13 JH</i>

Job Completion



*MF 09-01-12*

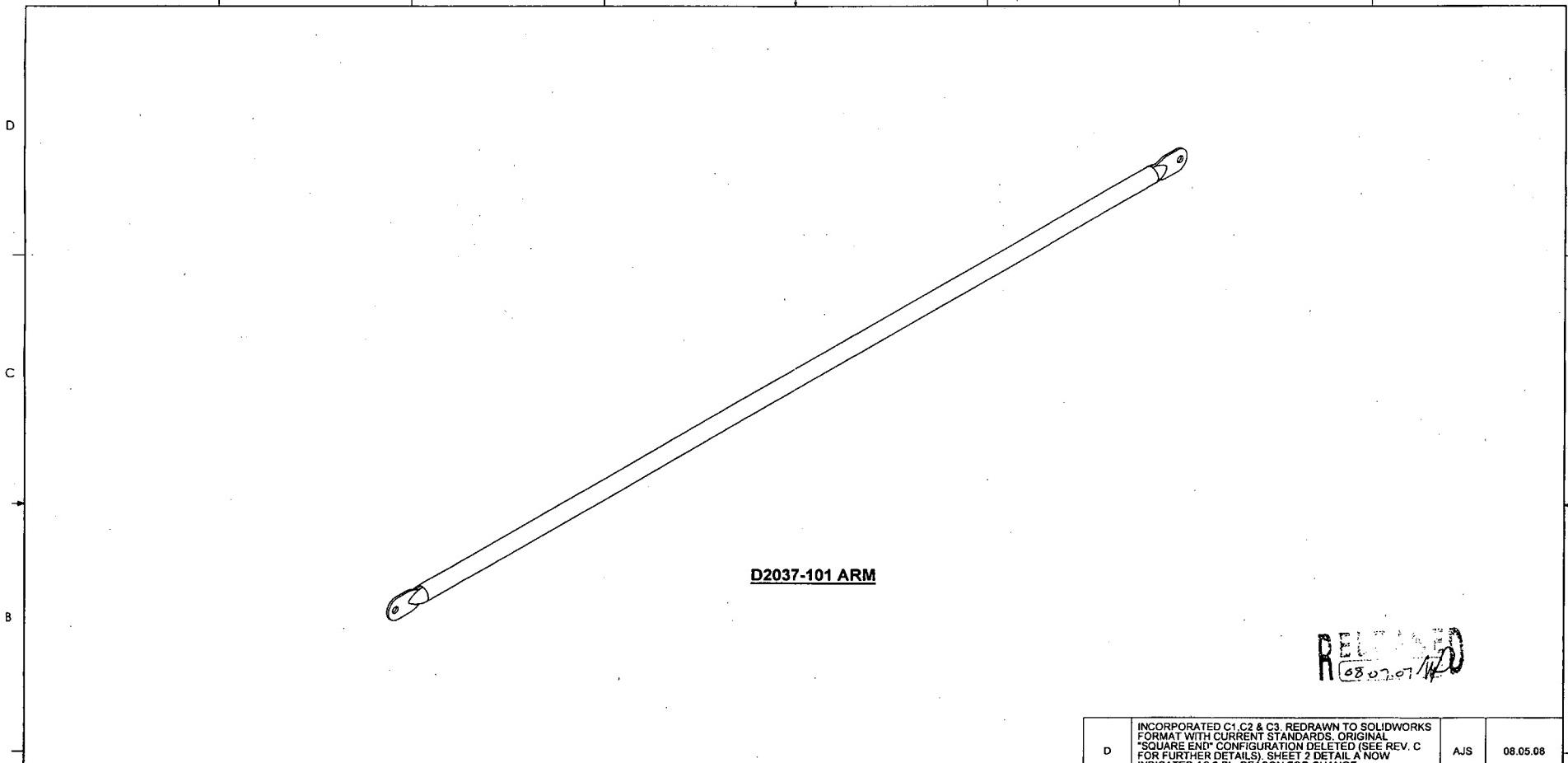
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

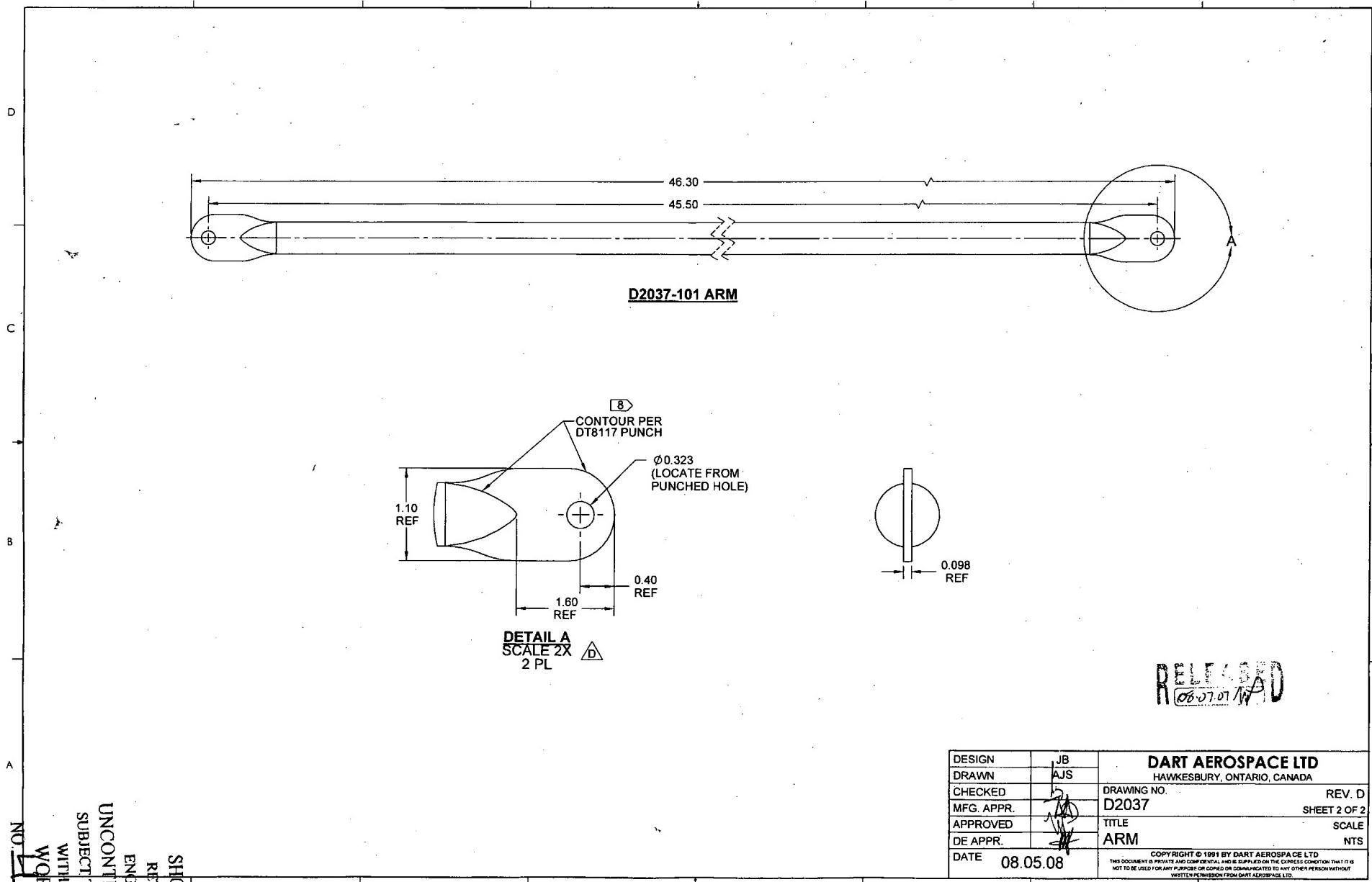


**NOTES:**  
 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, Ø 0.750 x 0.049 WALL  
     REF. DART SPEC M304TR0.750W.049  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1150 lbs  
 8) FOR FURTHER INFORMATION SEE DRAWING D2638.

WORK ORDER  
NO. 411316403  
TO AMENDMENT  
FOR ENGINEERING  
RETURN TO  
AMERICAN INSTITUTE OF CIVIL ENGINEERS  
COPY TO  
AMERICAN INSTITUTE OF CIVIL ENGINEERS  
TO AMENDMENT

D	INCORPORATED C1,C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JL	DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.05.08	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND RESTRICTED. ANY COPIES OR EXTRACTS THEREOF ARE EXPRESSLY PROHIBITED. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



RELEASER  
08/07/07

DESIGN	JB	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2037
APPROVED		REV. D
DE APPR.		SHEET 2 OF 2
DATE	08.05.08	TITLE
		ARM
		SCALE
		NTS

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